



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBT18520
Job Sheet 171728



002379

Part No: RBT18520

Job Qty: 2 ea

Part Name: Main Rotor Damper Load Test Device



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18520 REV:11 IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		2/27/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	2 pcs		2/28/18	0.08	0.67	Small Fab-9		MLL
110	QC	2 pcs		2/28/18	0.00	0.00	QC5		PD 18.04.11
130	Packaging	2 pcs		2/28/18	0.00	0.00	Packaging3-2		
140	QC21-FG	2 Ea		2/28/18	0.00	0.00	QC21		

Part Op 100 - Assemble

Descriptions: 130 - Identify and Stock

DAS
21
9:00

APR 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
10164	LG. Pistol Case, Plastic	2 Ea (1 ea)	100-Small Fab	
20625A914 ✓	Dial Indicator Attchmnt Agd-2 Dial	2 (1 ea)	100-Small Fab	5044126
5416K41 ✓	SS Hose Clamp 3.5" Dia.	2 Ea (1 ea)	100-Small Fab	5044125
90108A417 ✓	Flat Washer 3/8" Plated	4 Ea (2 ea)	100-Small Fab	5044121
91259A583 ✓	Shoulder Screw 5/16" Shoulder Dia, 1" L Shoulder, 1/4"-20 Thread	2 Ea (1 ea)	100-Small Fab	5015387
92845A245 ✓	18-8 Ss Extended (Dog) Point Socket Set Screw 10-24 Thread, 1/2" Length	4 Ea (2 ea)	100-Small Fab	5044124
93839A815 ✓	Hex Nut 3/8-24 Unf	4 Ea (2 ea)	100-Small Fab	5044120
95615A120 ✓	1/4-20 Nylock Nut	2 Ea (1 ea)	100-Small Fab	5044123
AGD-2 ✓	TBD Dial Indicator 0" to 1" range.	2 (1 ea)	100-Small Fab	5047587
FPSC4-10R ✓	TBD	2 (1 ea)	100-Small Fab	5044352
FPSC5-10R ✓	TBD	2 (1 ea)	100-Small Fab	5044353
RBT18520-1 ✓	Lift Device Frame	2 Ea (1 ea)	100-Small Fab	5048530
RBT18520-11A ✓	Weight Assembly	2 Ea (1 ea)	100-Small Fab	5055427
RBT18520-15	Clevis Bracket ATG	2 Ea (1 ea)	100-Small Fab	
RBT18520-16	Indicator Bracket ATG	2 Ea (1 ea)	100-Small Fab	
RBT18520-5 ✓	Weldment	2 Ea (1 ea)	100-Small Fab	5052061
RBT18520-7 ✓	Pivot Bar Weldment	2 Ea (1 ea)	100-Small Fab	5053641
RBT18520-9A	Extension Assembly	4 Ea (2 ea)	100-Small Fab	5058173

504096

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab	10164	2	0	0
90-Start up	20625A914	2	0	0
	5416K41	2	0	0

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐	Skid-tube ☐	Water Jet ☐ Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐		
		Use-as-is ☐	Thermoforming ☐		
		Suspected Unapproved ☐	Large Fab ☐		
Date :	Step #:	QTY Effect			
Description Work Order Deviation					
Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cu ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damaged ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Inco ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions In ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐				

90108A417	4	0	0
91259A583	2	4	0
92845A245	4	0	0
93839A815	4	0	0
95615A120	2	0	0
AGD-2	2	0	0
FPSC4-10R	2	0	0
FPSC5-10R	2	0	0
RBT18520-1	2	0	0
RBT18520-11A	2	0	0
RBT18520-15	2	0	0
RBT18520-16	2	0	0
RBT18520-5	2	0	0
RBT18520-7	2	0	0
RBT18520-9A	4	0	0

Part Specifications

Specifications could not be found.

Plex 2/8/18 6:47 AM Dart.lajeunesse.marie

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

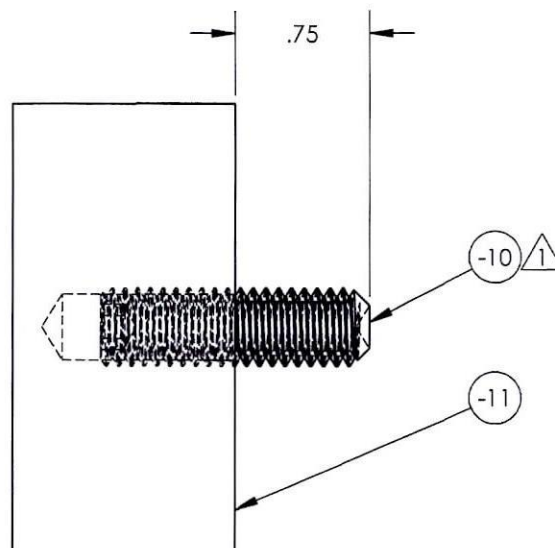
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
7		CHD P/N -10 SETSCREW DEPTH TO .75 PER G.E.	9/28/2009	RJC
10	16-0096	-11A ADDED TO BOM.	8/5/2016	DPD
11	17-0069	-11A CHD LOCTITE NUMBER WAS 609 IS 262.	3/22/2017	DPD



NOTE:

- 1 INSTALL -10 SOCKET HEAD SET SCREW USING 262 LOCTITE OR EQUIVALENT, ALLEN HEAD IN.



TITLE		ROTOR DAMPER TEST DEVICE	
DWG NO.		RBT18520-11A	
REV		11	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
DRAWN BY: COLE		.X ± .1 SURFACES = 125/✓	
CHECKED: MACKOVJAK		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY	
APPROVED: GILBERT		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 8/17/2000		USED ON MODEL	
SHEET 12 OF 17			

-11A

WEIGHT ASSEMBLY